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10 — 8.0

4.0 8.0 + 4

6.0

10.0

5.0

30.0

2.0 — 4.0 + 2

8.0

4.0 — 8.0 + 4

4.0

5.0 — 6.0 + 1

24.0

5.0

8.0

5.0

3.0

7.0

10.0

11.0

7.0

10.0

10.0

10.0

10.0

9.0

16.0

1227.0

238 hours for 10 units shop

100 hours for 10 unit shop

225 hours

[redacted] hours labor

100 on part electronics

20 on parts mechanical

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#1

2509

AUTOMATIC KEYER

TIME + MATL ESTIMATE FOR 10 + 50 UNITS

BARS, FRAME, BASE 2 REQD./UNIT.

BLANK SIZE = 1/4 x 3/8 C.R. STL. STOCK X 12 1/2" LONG.

MAT'L { 10 UNITS REQUIRES " = 21 FT. = $.
50 UNITS " 105 FT. = $.

TIME { 10 UNITS MACHINING AND BENCH TIME = 8.0 HRS.
50 UNITS " " " " = 34.0 HRS.

BARS, FRAME, TOP 2 REQD/UNIT

BLANK SIZE = SAME AS ABOVE.

MAT'L. { 10 UNITS REQUIRES 21 FT = $.
50 " " 105 FT. $.

TIME { 10 UNITS MACHINING AND BENCH TIME = 8.0 ARS.
50 UNITS " " " " = 34.0 HRS.

BOARD, CHASSIS 1 REQD./UNIT

BLANK SIZE = 12 7/16 x 5 7/8 x 1/16 THICK EPOXY GLASS COPPER CLAD

LOW. FLOHR
MAT'L. { 10 UNITS REQUIRE 750 sq in = $.
50 UNITS " 3750 sq. in = $.

TIME { 10 UNITS CUTTING TO SIZE + DR. ALL HOLES = 6 HRS
50 UNITS " " " " " " = 30 HRS

BOARDS, PLUG IN (B-1, B-2, B-3, B-4, B-5, POWER SUPPLY)

Matl is figured by L. Flohr + Al. Salmon.

TIME { 10 UNITS CUT TO SIZE + DR. HOLES = 10 HRS
50 UNITS " " " " " = 50 HRS

SCREWS AND NUTS FOR 10 UNITS = ?

" " " " 50 UNITS = ?

SPRINGS 2 ER UNIT

10 UNITS 5.0

50 0.0

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#2

COVER, FRONT + BACK 1 REQD EACH/UNIT TOTAL 20 COVERS + 100 COVERS

BLANK SIZE = 7 1/4 x 5 3/16 x .048 CRSTL

MATL { 10 UNITS REQUIRES 752 sq. in = $.
50 UNITS " 3760 sq. in = $.

TIME { 10 UNITS, TOTAL SHOP TIME = 30 HRS.
50 UNITS " " " = 150 HRS.

COVER, CHASSIS 1 REQD / UNIT

BLANK SIZE: 11 X 13 3/4 X .038 PERFORATED C.R.S.T.L.

MAT'L { 10 UNITS REQUIRES 152 sq. in. = $.
50 UNITS " 760 sq. in = $.

TIME { 10 UNITS TOTAL SHOP TIME = 4.0 HRS.
50 UNITS " " " = 12.0 HRS.

ARM 2 REQD / UNIT

BLANK SIZE = 1 3/4 x 3/8 x 1/4 FABRIC PHENOLIC

MAT'L { 10 UNITS REQUIRES 7.50 sq. in of 1/4" MATL = $.
50 UNITS " 37.50 sq in of 1/4" MATL = $.

TIME { 10 UNITS TOTAL SHOP TIME = 8.0 HRS.
50 UNITS " " " = 40.0 HRS.

PLATE, MOUNTING 1 REQD/UNIT

BLANK SIZE = 3 7/16 x 3 1/16 X .048 C.R.S.T.L.

MAT'L { 10 UNITS REQUIRES 105.3 sq. in = $.
50 UNITS " 526.5 sq. in = $.

TIME { 10 UNITS TOTAL SHOP TIME = 8.0 HRS.
50 UNITS " " " = 24.0 HRS.

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#3

SPACER, TRANSFORMER 4 REQD/UNIT

SPACER, TRANSFORMER BRACKET 2 REQD/UNIT

BLANK SIZE : 3/8" DIA. ROD x 7/16 LONG FABRIC PHENOLIC.

MATL { 10 UNITS REQUIRES 30 in of 3/8 DIA ROD. $
50 UNITS " 150 in of 3/8 DIA ROD. $

TIME { 10 UNITS TOTAL SHOP TIME = 4.0 HRS
50 UNITS " " " = 20.0 HRS

KNOB 1 REQD/UNIT

BLANK SIZE = 5/8 DIA X 7/8 LONG ALUMINUM ROD.

MATL { 10 UNITS REQUIRES 9 in = $
50 UNITS " 45 in = $

TIME { 10 UNITS TOTAL SHOP TIME = 6.0 HRS
50 UNITS " " " = 25.0 HRS

PLATE, MOUNTING 1 REQD/UNIT

BLANK SIZE = 2 5/8 X 2 1/8 x 3/8 THICK FABRIC PHENOLIC.

MATL { 10 UNITS REQUIRES 40 sq. in = $
50 UNITS " 200 sq. in = $

TIME { 10 UNITS TOTAL SHOP TIME = 24.0 HRS
50 UNITS " " " = 120.0 HRS

PLATE, BOTTOM 1 REQD/UNIT

BLANK SIZE = 11 X 5 13/16 X 1/16 THICK FABRIC PHENOLIC.

MATL { 10 UNITS REQUIRES 5.0 sq ft. = $
50 UNITS " 25.0 sq. ft. = $

TIME { 10 UNITS TOTAL SHOP TIME = 5.0 HRS
50 UNITS " " " = 25.0 HRS

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PADDLE (#1 + #2) 1 EACH REQD/UNIT

BLANK SIZE = 3 1/8 x 1 1/4 x 1/8 THICK BLACK FABRIC PHENOLIC

MAT'L { 10 UNITS REQUIRES 80.0 sq. in. = $.
50 UNITS " 400.0 sq. in. = $.

TIME { 10 UNITS TOTAL SHOP TIME = 8.0 HRS.
50 UNITS " " " = 40.0 HRS.

CONTACT 2 EA REQD/UNIT

BLANK SIZE = 1/8 DIA x 1/4 LONG COIN SILVER

MAT'L { 10 UNITS REQUIRES 5 in. = $.
50 UNITS " 25 in. = $.

TIME { 10 UNITS TOTAL SHOP TIME = 5.0 HRS.
50 UNITS " " " = 25.0 HRS.

CONTACT STRIP 2 EACH REQD/UNIT

BLANK SIZE = 1 3/4 x 1/4 x .006 THICK PHOSPHOR BRONZE

MAT'L { 10 UNITS REQUIRES 5 sq. in = $.
50 UNITS " 25 sq. in = $.

TIME { 10 UNITS TOTAL SHOP TIME = 3.0 HRS.
50 UNITS " " " = 15.0 HRS.

BEARING 2 EACH/UNIT

BLANK SIZE = 1/2 DIA x 1/2 LONG BRASS ROD

MAT'L { 10 UNITS REQUIRES 5 in. = $.
50 UNITS " 25 in. = $.

TIME { 10 UNITS TOTAL SHOP TIME = 7.0 HRS.
50 UNITS " " " = 35.0 HRS.

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BEARING BLOCK 2 EACH REQD/UNIT

BLANK SIZE = 1/4 x 1/2 x 9/16 LONG BRASS

MATL { 10 UNITS REQUIRES 12 in of 1/4 x 1/2 MATL. = $
50 UNITS " 60 in " " " " = $

TIME { 10 UNITS TOTAL SHOP TIME = 10 HRS.
50 UNITS " " " = 50 HRS.

CAM SHAFT 2 EACH REQD/UNIT

BLANK SIZE = 3/8 DIA x 1 3/8 LONG BRASS ROD

MATL { 10 UNITS REQUIRES 28 in of 3/8 DIA ROD = $
50 UNITS " 12 ft. of " " " = $

TIME { 10 UNITS TOTAL SHOP TIME = 11.0 HRS
50 UNITS " " " = 55.0 HRS

SPRING LOAD BLOCK 2 EACH REQD/UNIT

BLANK SIZE = 3/8 x 3/8 x 9/16 LONG BRASS

MATL { 10 UNITS REQUIRES = 12 in of 3/8 x 3/8 STOCK = $
50 UNITS " = 57 in " " " " " = $

TIME { 10 UNITS TOTAL SHOP TIME = 7.0 HRS.
50 UNITS " " " = 35.0 HRS.

Cam 2 EACH REQD/UNIT

BLANK SIZE = 3/4 DIA x 5/16 LONG BRASS ROD

MATL { 10 UNITS REQUIRES 6 1/2 in of 3/4 DIA STOCK = $
50 UNITS " 32 in " " " " = $

TIME { 10 UNITS TOTAL SHOP TIME = 10.0 HRS
50 UNITS " " " = 50.0 HRS

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SUPPORT 1 REQD/UNIT

BLANK SIZE = 2 3/8 x 5/8 x 1/8 THICK BLACK FABRIC PHENOLIC

MAT'L { 10 UNITS REQUIRES 15 sq. in = $.
50 UNITS " 75 sq. in = $.

TIME { 10 UNITS TOTAL SHOP TIME = 10.0 HRS
50 UNITS " " " = 50.0 HRS

SUPPORT POST 1 REQD/UNIT

BLANK SIZE = 3/4 DIA x 1 3/8 LONG BRASS ROD

MAT'L { 10 UNITS REQUIRES 14 in of 3/4 DIA STOCK: $.
50 UNITS " 70 in " " " " : $.

TIME { 10 UNITS TOTAL SHOP TIME = 10.0 HRS.
50 UNITS " " " = 50.0 HRS.

SPRING LOAD SCREW 2 EACH REQD/UNIT

BLANK SIZE 3/4 DIA x 3/4 LONG BRASS ROD

MAT'L { 10 UNITS REQUIRES 8 in of 3/4 DIA STOCK: $.
50 UNITS " 38 in " " " " = $.

TIME { 10 UNITS TOTAL SHOP TIME = 10.0 HRS.
50 UNITS " " " = 50.0 HRS.

PAINT + OTHER FINISHING

MAT'L COST FOR 10 UNITS — ?
" " " 50 UNITS : ?

TIME FOR 10 UNITS = 6 HRS
" " 50 UNITS = 16 HRS

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ASSEMBLY TIME FOR 10 UNITS = 16 HRS
" " " 50 UNITS = 80 HRS

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